

Date: Tuesday, 4/25/2006 1:55:27 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLADE FITTING
Job Number : 26838	
Estimate Number : 12299	
P.O. Number : <i>N/A</i>	Part Number : D3488041
This Issue : 4/25/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3488 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 26189	Material : <i>N/A</i>
Written By : <i>See comment below</i>	Due Date : 5/20/2006
Checked & Approved By : <i>06-04-25</i>	Qty: <i>17</i> Um: Each
Comment : Est Rev:A New Issue 06-02-28 JLM Est Rev:B As per Rev B 06-03-30 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6103003	alum billet
-----	----------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Alluminum Round Billet D6103-003

Batch: *B25806 B27033*

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Dwg DSK 101 & Folio FA625

2-Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA625 & Dwg D3488

2-Deburr

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/05/31		Remove dim 0.793 from dimension sheet. cannot measure correctly. (both sheets D3488-2/D3488-1)	Ep	06/05/31			<i>[Signature]</i> 06-05-31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/06/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/30	4	Part is too short holes in wrong side place the origin in the folio was not correct		verify position of origin and correct the folio Scrap and Replace				
06/05/30	4	Dimension 1.317" is too thin its 1.290" tool pulled out of holder.		changed tool holder and Remasured tool		on original	<i>[Signature]</i> 06-05-31	

NOTE: Date & initial all entries

uesday, 4/25/2006 1:55:27 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 26838

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Ep 06/05/31 X1

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-05-31 (1)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

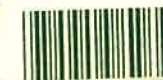
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-31 (1)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/05/31 (1)

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert 418293

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

DL 06/05/31 (1)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 06 06 01 (1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 23

DL 06/05/01 (1)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 26838

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 26/06/01

Job Completion



LC 06-06-01

DART AEROSPACE LTD		Work Order:	26838
Description: Blade Fitting, LH		Part Number:	D3488-1
Inspection Dwg: D3488	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.130	✓			
2.620	+/-0.010	2.619	✓			
0.703	+/-0.010	0.703				cannot measure correctly / remove
1.351	+/-0.010	1.341	✓			
1.317	+/-0.010	1.316	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.803	✓			
Ø0.508	+0.006/-0.001	0.508	✓			
R0.062	+/-0.010	R0.062	✓			
1.500	+/-0.010	1.502	✓			
8.000	+0.030/-0.000	8.007	✓			
11.18	+/-0.030	11.176	✓			
Ø0.484	+0.005/-0.001	0.484	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.150	✓			
3.070	+/-0.010	3.067	✓			
0.590	+/-0.010	0.580	✓			
0.125	+/-0.010	0.120	✓			
1.005	+/-0.010	1.005	✓			
3.500	+/-0.010	3.497	✓			
Ø0.297	+0.005/-0.000	0.297	✓			
Ø0.430	+/-0.010	0.425	✓			
0.100	+/-0.010	0.097	✓			

Measured by: J.G	Audited by: Ep	Prototype Approval:	N/A
Date: 06/05/31	Date: 06/05/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
46	DSK101	Blade Fitting	1110

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, May 24, 2006

